Date:

Monday, 23/03/2009 9:53:09 AM

User: Julie Dawson

Process Sheet

Customer Job Number

: CU-DAR001 Dart Helicopters Services

Estimate Number

: 46634 : 10104

P.O. Number

This Issue

: 23/03/2009

: NC

Prsht Rev. First Issue **Previous Run**

: //

: 45074

Type

S.O. No. :

: SMALL /MED FAB

Part Number

Due Date

Drawing Name

: D2012107

: CLEVIS

. D2012-107 REV. C

Drawing Number Project Number

: N/A

: C **Drawing Revision**

Material

: 10/04/2009

Qty:

Each 40 Um:

Written By

Checked & Approved By

Comment

Re-format, Drawing to Rev. C SM : Est: D 01.11.08

Est Rev:E Now on Waterjet 06-06-13 JLM

Additional Product

Job Number:



Seq. #:

Description:

1.0

M304S16GA

304/316 Sheet .063



Comment: Qty.:

Total:

0.6720 sf(s)

304/316 .063 Sheet

(M304S063)

Batch: 11133

R9-4-20

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2012-107

Dwg Rev:_

Prog Rev:_

B9-4-20

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B9-4-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

4.0

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	I THE	proval espector
			1 & Smoll					

Part No: <u>D2012-107</u>	PAR #: N/A	Fault Category	Prod fine nosy med	₹5mαl/ NCR: (Yes)No	DQA:	Date: 07/04/28
Resolution:	SCIAP	Disposition: _	SCIAP	QA: N/C Closed	<u></u>	Date: 09/04/25

NCR: 46634		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B			Ammanual	Appr	·oval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng		nspector
9/4/23	5.0	2 parts SCRAP. they were not Positioned correctly in 5:5 cuessing Parts lo be "cracled"		SCRAP and Destron Oty @ No Replace	9/0/3	Salarl23	anon	100	, H. P.
		P.C. Humman erron LACK of Altenhan.							

NOTE: Date & initial all entries

Monday, 23/03/2009 9:53:10 AM Date: User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: CLEVIS** Job Number: 46634 Part Number: D2012107 Job Number: Seq. #: **Machine Or Operation: Description:** 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ 8.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace L	Ltd
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	-									1
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr		roval spector
								' 		
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	↓ A:	Date:		
		solution:								
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NCF	R)				
DATE	STEP	Description of NC		Corrective Action Section B			Sime Verification Appro			roval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a		on C	Chief Eng		nspector
					1			I	1	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 14/010/324		
Description: Clevis	Part Number:	D2012-107	
Inspection Dwg: D2012 Rev: C		Page 1 of 1	

		FIR	ST ARTICLE	INSPEC	TION CHE	ECKLIST		
			X First A	rticle [Prot	otype		
	rawing nension	Tolerance	Actual Dimension	Accept	Reject	Method o	1.0	omments
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,	1.325	+/-0.010	1394	-				•
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(0.750	+/-0.010	,754	20				
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	•	-						
		1	l				I	
Meas	ured by:	图	Audited b	- 1 - 1		Prototype Approval:		N/A
	Date:	9-4-20	Dat	te: 0964	20		Date:	N/A
Rev	Date	Change			16.54		Revised by	Approved
A	07.02.02	New Issue					KJ/JLM	

Rev	Date	Change	Revised by Ap	prov <i>e</i> d
Α	07.02.02	New Issue	KJ/JLM A	Tel 1
			10 7	7

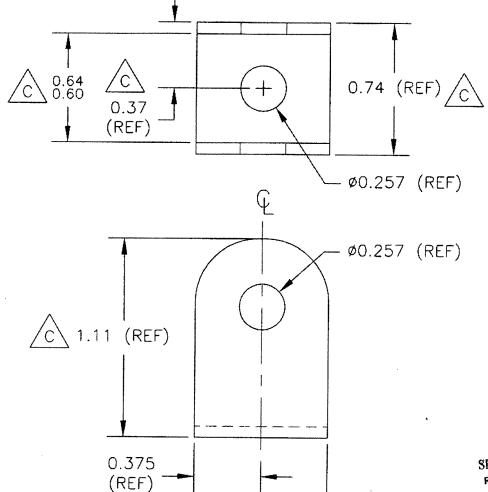




١	DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
)	CHECKED	APPROVED	DRAWING NO. REV. C	c
,	T	1 A	D2012-107 SHEET 1 OF 2	2
	DATE		TITLE SCALE	Ē
	99.12.20		CLEVIS 2:	1
	Α	94.10.27	NEW ISSUE	-
	В	99.04.30	ADD FLAT PATTERN	



99.12.20		CLEVIS	2:1
А	94.10.27	NEW ISSUE	
В	99.04.30	ADD FLAT PATTERN	
С	99.12.20	0.74 WAS 0.680	



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MATERIAL: AISI 304/316 SS 0.063 THICK

USE 0.032 BEND RADIUS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

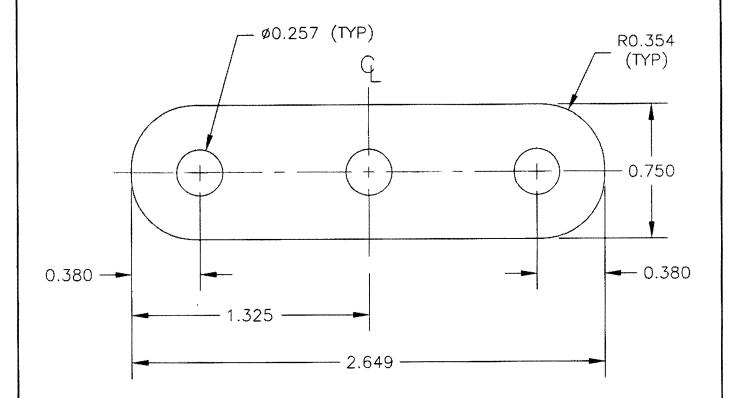
0.750

(REF)



DESIGN BW	DRAWN BY		OSPACE LTD ontario, canada
CHECKED.	APPROVED H	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATÉ.		TITLE	SCALE
99.12.20		CLEVIS	2:1





D2012-107 FLAT PATTERN

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WORK OBJER

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